Dart Aerospace Ltd.

Date: Tuesday, 8/22/2006 2:15:23 PM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: MOUNTING PLATE
Job Number	: 28301		
Estimate Number	: 12408		
P.O. Number	:	**Part Number**	: D34992
This Issue	: 8/22/2006 **S.O. No.** :	**Drawing Number**	: D3499 UNDER REVIEW
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : SMALL/MED FAB	**Drawing Revision**	: U/R
Previous Run	: 27209	**Material**	:
Written By	: 06-08-22	**Due Date**	: 8/29/2006 **Qty:** 1 **Um:** Each
Checked & Approved By	:		
Comment	: Est Rev A New Issue 06-05-05 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S125	6061-T6 .125 Sheet

Comment: Qty.: 1.1214 sf(s)/Unit Total : 1.1214 sf(s)
6061-T6 .125 Sheet
(M6061T6S0125)
Batch: M100947

2.0	WATER JET	FLOW WATER JET

Comment: FLOW WATER JET
1-Cut as per Dwg D3499
Dwg Rev: UR
Prog Rev: PREL ?

2-Deburr if necessary JAD 06:08:23 1

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE JAD 06:08:23 1

4.0	QC8	SECOND CHECK

Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr if necessary.

Qty only

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Job Number: 28301 **Part Number:** D34992

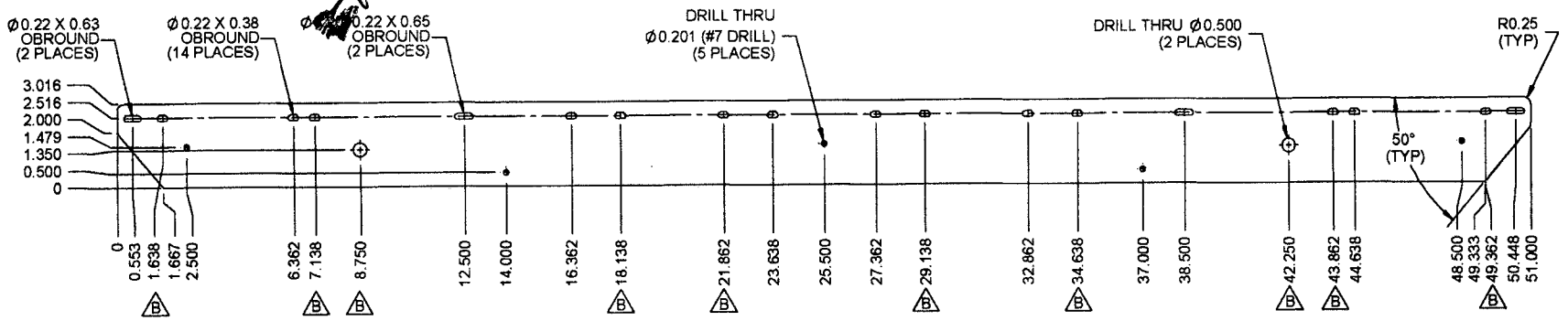
Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	BRAKE NC	NC BRAKE
	Comment: NC BRAKE Bend as per Dwg D3499	
7.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	
8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	
9.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	
10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	
11.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location:_____	
12.0	DC	DOCUMENT CONTROL
	Comment: DOCUMENT CONTROL Inspection Level 21	

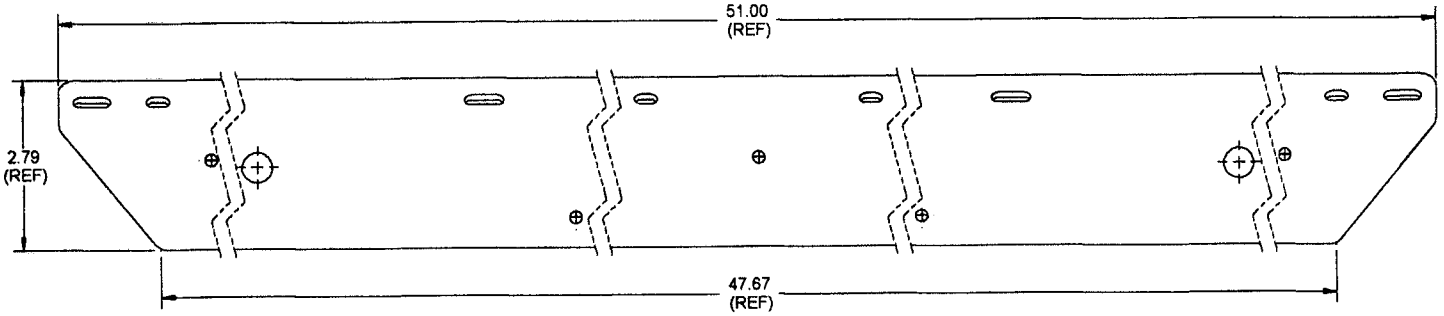
Job Completion

1 D6/22/07

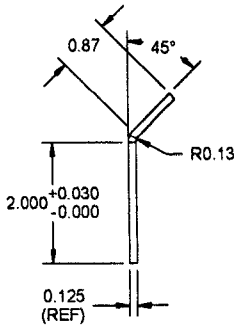
Form: rprocess



D3499-2F MOUNTING PLATE FLAT PATTERN
SCALE 1 : 4



D3499-2 MOUNTING PLATE



D3499-2 BENDING DETAIL

NOTES:

1) MATERIAL: 6061-T6 ALUMINUM SHEET (0.125 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.125)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005. 4.1
POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

PRELIMINARY ISSUE

DESIGN	DRAWN BY	**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3499 REV. B SHEET 2 OF 4
DATE 06.08.15		TITLE CABLE GUARD SCALE 1:2

DART AEROSPACE LTD	Work Order:	28301
Description:	Part Number:	D34992
Inspection Dwg: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [X] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.553	±0.010	0.557	✓		Vern	
1.638	±0.010	1.643	✓		Vern	
1.667	±0.010	1.670	✓		measuring tape	
2.500	±0.010	2.495	✓		Vern	
6.362	±0.010	6.370	✓		Vern	
7.138	±0.010	7.148	✓		Vern	
8.750	±0.010	8.745	✓		Vern	
12.500	±0.010	12.509	✓		Vern	
14.000	±0.010	14.009	✓		Vern	
16.362	±0.010	16.370	✓		measuring tape	
18.138	±0.010	18.130	✓		measuring tape	
21.862	±0.010	21.870	✓		measuring tape / vern	
23.638	±0.010	23.630	✓		measuring tape / vern	
25.500	±0.010	25.500	✓		measuring tape / vern	
27.362	±0.010	27.362	✓		measuring tape / vern	
29.138	±0.010	29.130	✓		measuring tape / vern	
32.862	±0.010	32.860	✓		measuring tape / vern	
34.638	±0.010	34.630	✓		measuring tape / vern	
37.000	±0.010	37.000	✓		measuring tape / vern	
38.500	±0.010	38.500	✓		measuring tape	
42.250	±0.010	42.260	✓		measuring tape	
43.862	±0.010	43.870	✓		measuring tape / vern	
44.638	±0.010	44.630	✓		measuring tape / vern	

Measured by:	SAD
Date:	06:08:23

Audited by:	
Date:	

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD	Work Order:	
Description:	Part Number:	
Inspection Dwg: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [X] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
48.500	±0.010	48.500	✓		measuring tape	
49.333	±0.010	49.340	✓		measuring tape Vern	
49.362	±0.010	49.362	✓		measuring tape	
50.448	±0.010	50.500	✓		measuring tape	
51.000	±0.010	51.000	✓		measuring tape	
3.016	±0.010	3.022	✓		Vern	
2.516	±0.010	2.522	✓		Vern	
2.000	±0.010	2.000	✓		Vern/M-T	
1.479	±0.010	1.486	✓		Vern	
1.350	±0.010	1.354	✓		Vern	
0.500	±0.010	0.501	✓		Vern	
Ø0.22	±0.030	0.217	✓		Vern	
r0.63	±0.030	0.629	✓		Vern	
0.22	±0.030	0.225	✓		Vern	
0.38	±0.030	0.385	✓		Vern	
0.22	±0.030	0.217	✓		Vern	
0.65	±0.030	0.650	✓		Vern	
Ø0.201	+0.006/-0.001	Ø0.207	✓		Vern	
Ø0.500	+0.006/-0.001	Ø0.507	✓		Vern	
0.125	±0.010	0.125	✓		Vern	

Measured by:	SAD
Date:	06.08.23

Audited by:	
Date:	

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	